

Work Order ID 129889

129889

Page 1

February-23-15 10:30:52 AM

Item ID: D206-802-031 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Passenger Door Opener LH
 Start Date: 2/16/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 15-02-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-031 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
27
5-33

1x

MAY 04 2015

DAS
26
9-39

DAS
27
5-33

APR 30 2015

68-

1x

DAS
46
9-39

MAY 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00				(1x)	DAS 46	MAY 01 2015	
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-031								
	Location: <u>FG021</u>								
	PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MCS MAY 04 2015
 MCS MAY 04 2015

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Material									
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Training									
Transport									
Unapproved									

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Picklist Print

February-23-15 10:30:51 AM

Page 1

Work Order ID: 129889

129889

Parent Item: D206-802-031

D206-802-031

Parent Item Name: Passenger Door Opener LH

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 Door Prop	D3552-17 DAS 46 9-89	Manufactured	No			105	Each	13.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST364				13					
				103639				1					
				26847				12					
D3622-5 Ball Stud	D3622-5 DAS 46 9-89	Manufactured	No			105	Each	24.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST052				24					
				104978				24					
D4115-5 Doubler	D4115-5 DAS 46 9-89	Manufactured	No			105	Each	0.0000	1	1			
D4115-041 Litter Door Bracket Assembly	D4115-041 DAS 46 9-89	Manufactured	No			105	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST092				1					
				97607				1					

APR 30 2015

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Doc/Data									
Equip/Tooling									
Handling/Pre									
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Operator									
Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

February-23-15 10:30:51 AM

Page 2

Work Order ID: 129889

Parent Item: D206-802-031

Parent Item Name: Passenger Door Opener LH

129889

D206-802-031

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

CR3242-5-4

Purchased

No

105

Each

75.0000

3 3

CR3242-5-4

Rivet

DAS

46

9-89

Location

Loc Qty

Loc Code

ST317

75

75

68.0000

2 2

CR3243-5-4

Purchased

No

105

Each

68.0000

2 2

CR3243-5-4

Rivet

DAS

46

9-89

Location

Loc Qty

Loc Code

ST317

68

68

2,515.000

2 2

MS20426AD4-5

Purchased

No

105

Each

2,515.000

2 2

MS20426AD4-5

RIVET

DAS

46

9-89

Location

Loc Qty

Loc Code

GA

2441

m125807

60

m130922

2381

ST312

74

m125807

74

MS20600-AD4W2

Purchased

No

105

Each

1,001.000

9 9

MS20600-AD4W2

Rivet

DAS

46

9-89

Location

Loc Qty

Loc Code

CCK004

800

m126475

800

GA

154

m125708

154

ST309

47

m126475

47

DAS

27

9-89

DAS

27

9-89

DAS

27

9-89

DAS

27

9-89

APR 30 2015

February-23-15 10:30:51 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:30:51 AM

Page 3

Work Order ID: 129889

Parent Item: D206-802-031

Parent Item Name: Passenger Door Opener LH

129889

D206-802-031

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

52.0000

11
**

1

DAS
27
9-89

MS21073L5

Anchor Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

ST300

52

m130799

6

m131187

46

NAS1149C0532R

Purchased

No

105

Each

477.0000

33
**

3

DAS
27
9-89

NAS1149C0532R

WASHER

DAS
46
9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

415

m128537

215

m131624

200

NAS1149C0563R

Purchased

No

105

Each

346.0000

33
**

3

DAS
27

NAS1149C0563R

Washer

DAS
46
9-89

Location

Loc Qty

Loc Code

ST271

346

m125928

5

m131026

341

APR 30 2015

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